

Date: Monday, 6/12/2006 2:27:15 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI-UTILITY BASKET RH
Job Number : 27487	
Estimate Number : 12433	
P.O. Number : <i>N/A</i>	Part Number : D205541044
This Issue : 6/12/2006 S.O. No. : <i>N/A</i>	Drawing Number : IIN D205-541 REV F
Prsht Rev. : NC	Project Number :
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : F
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>SKA COMMENT REK</i>	Due Date : 6/19/2006 Qty: 1 Um: Each
Checked & Approved By : <i>06.06.12</i>	
Comment : Est Rev: C Re-Format 02-08-30 KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	27487A	350/212/130 BASKET LID
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Comment: Sub-Component 350/212/130 BASKET LID

2.0	27487B	212 BASKET BASE ASS'Y LH
-----	--------	--------------------------



Comment: Sub-Component 212 BASKET BASE ASS'Y LH

3.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD205-541-044 **CHG002**

KP 06.06.13 ①

4.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch: *B25815*

5.0	D2258300	Placard
-----	----------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: *B16384*

6.0	D2332041	Lid Prop Assembly 6.69"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lid Prop Assembly 6.69"

Batch: *B26880*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 27487

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch: B26406

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring

Batch: B24532

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: B26468

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bumper

Batch: B21139

11.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M100564

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M19278

13.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M18822

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:	Machine Or Operation:	Description :
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14.0	AN424A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M17204

15.0	AN517A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M100771

16.0	AN960JD416	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M100575

17.0	AN960JD416L	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M101237

18.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M19185

19.0	AN960JD8	Washer
------	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M11989

20.0	AN9704	Washer
------	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M100151

W/O:		WORK ORDER CHANGES					
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Job Number: 27487

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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21.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M100393

22.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M19085

23.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M17694

24.0	MS20600AD4W3	Cherry Rivets
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: M14393

Ref 19 (1)

25.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg.

SAD

M.F.

06-06-21

(1)

26.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

06-06-22 (1)

27.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

W/O:		WORK ORDER CHANGES					
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Job Number: 27487

Part Number: D205541044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0	D21991	Struts, 19"
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Struts, 19"
Batch: B2388 ✓

29.0	D219923	Strut
------	---------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Strut
Batch: B10750 B11406 B12793 ✓

30.0	D219925	Strut
------	---------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Strut
Batch: B11407 B10731 B12794 ✓

31.0	D2498	Mounting Bracket
------	-------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Mounting Bracket
Batch: B17625 ✓

32.0	D2499	Mounting Bracket
------	-------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Mounting Bracket
Batch: B17619 ✓

33.0	D2515	Bushing
------	-------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bushing
Batch: B18029 ✓

34.0	D30521	Mounting Lug
------	--------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Mounting Lug
Batch: B18143 ✓

W/O:		WORK ORDER CHANGES					
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Job Number: 27487

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M19278 ✓

36.0

AN412A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Batch: M100651 ✓

37.0

AN413A

Bolt



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Bolt

Batch: M10149 ✓

38.0

AN414A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M15072 ✓

39.0

AN57A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M18536 ✓

40.0

AN513A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M15922 ✓

41.0

AN960JD416

Washer



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Washer

Batch: M100575 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 27487

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch: M1928 ✓

43.0

MS21042L4

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Batch: M19085 ✓
M10065T ✓

44.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M17694 ✓
M101K47 ✓

06/12/09 (1)

45.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AR 06/06/01 (1)

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-541-044

Location:

PPP Rev: FE

06/06/02 (1)

47.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/23

Job Completion



U. 06.06.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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2. GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

CONTINUING AIRWORTHINESS

This installation should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D205-541.

3. INSTALLATION PROCEDURE

1. If required, install D2498 (STA 84.29), D2499 (STA 155.06), and D3052-1 (STA 129.00) per Figure 5.
2. Locate the D205-541-043/-044 **Utility-Basket™** as shown in Figure 1.
3. Attach the Basket to the A/C hardpoints at STA 84.29, STA 129.00, STA 155.06 as shown in Figures 2, 3, and 4 respectively.
4. Torque AN4 bolts 50-70 in-lbs (5.6-7.9 N-m). Torque AN5 bolts 100-140 in-lbs (11.3-15.8 N-m).
5. If the D3052-1 mounting lug & D2199-1 strut are not installed (at STA 129), the D2258-300 placard on the lid of the basket should be replaced with the D2258-220 placard. The D2258-220 placard can be purchased from Dart.

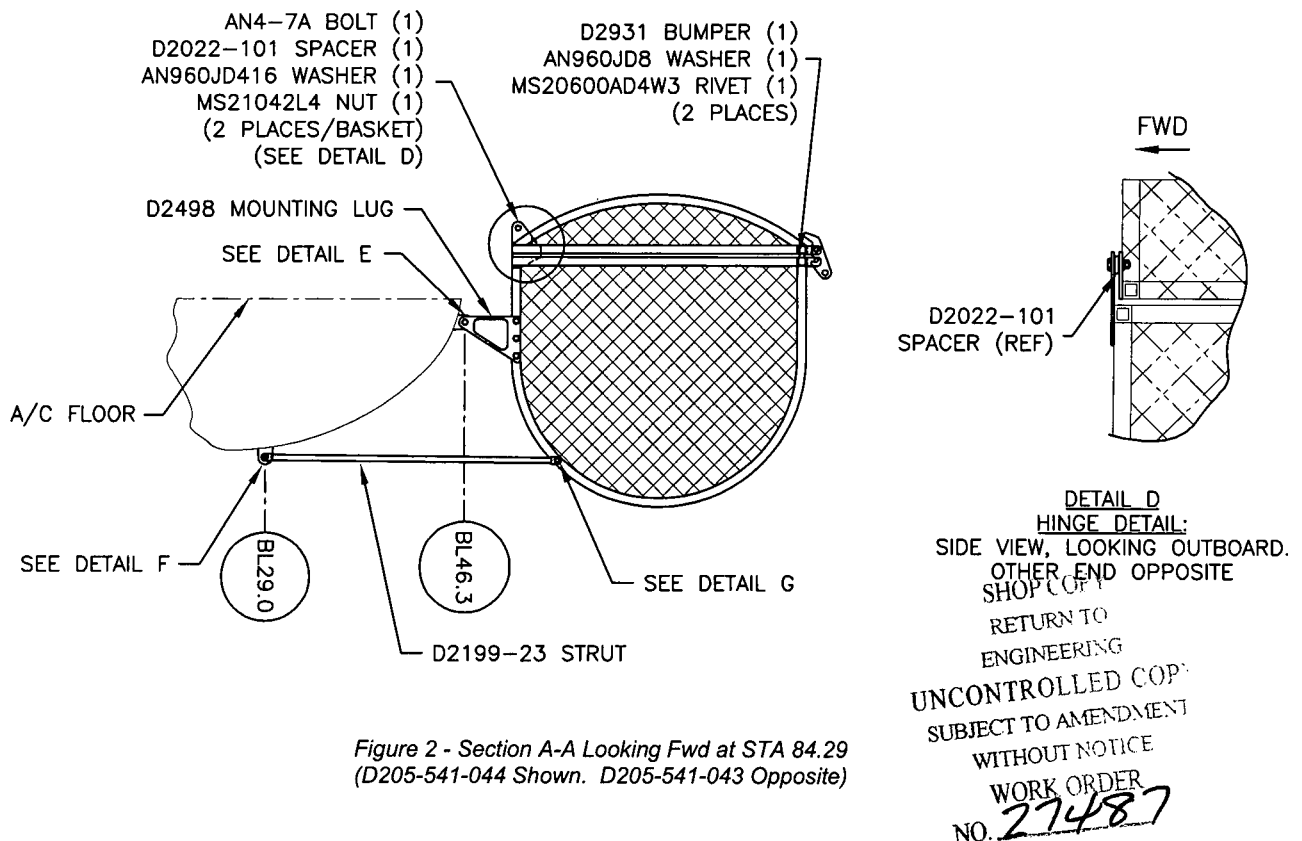


Figure 2 - Section A-A Looking Fwd at STA 84.29
(D205-541-044 Shown. D205-541-043 Opposite)

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Revision: **F**

Date: 06.04.19

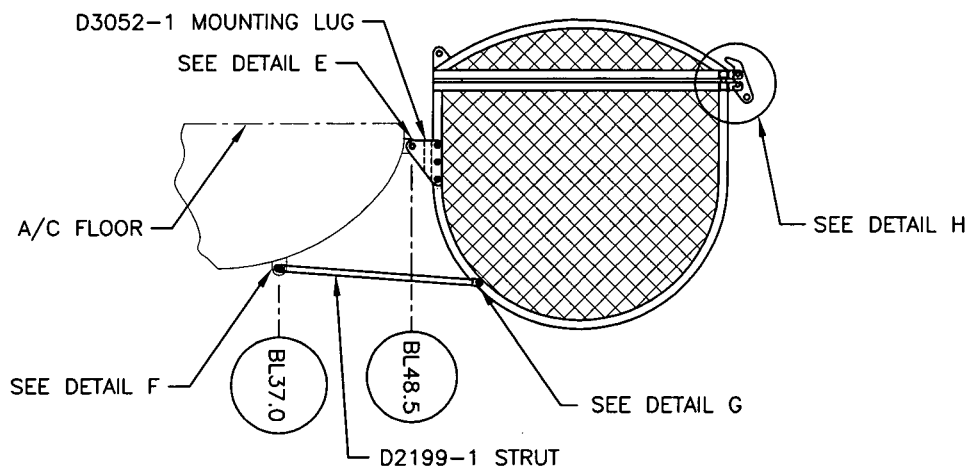


Figure 3 - Section B-B Looking Fwd at STA 129.00
(D205-541-044 Shown. D205-541-043 Opposite)

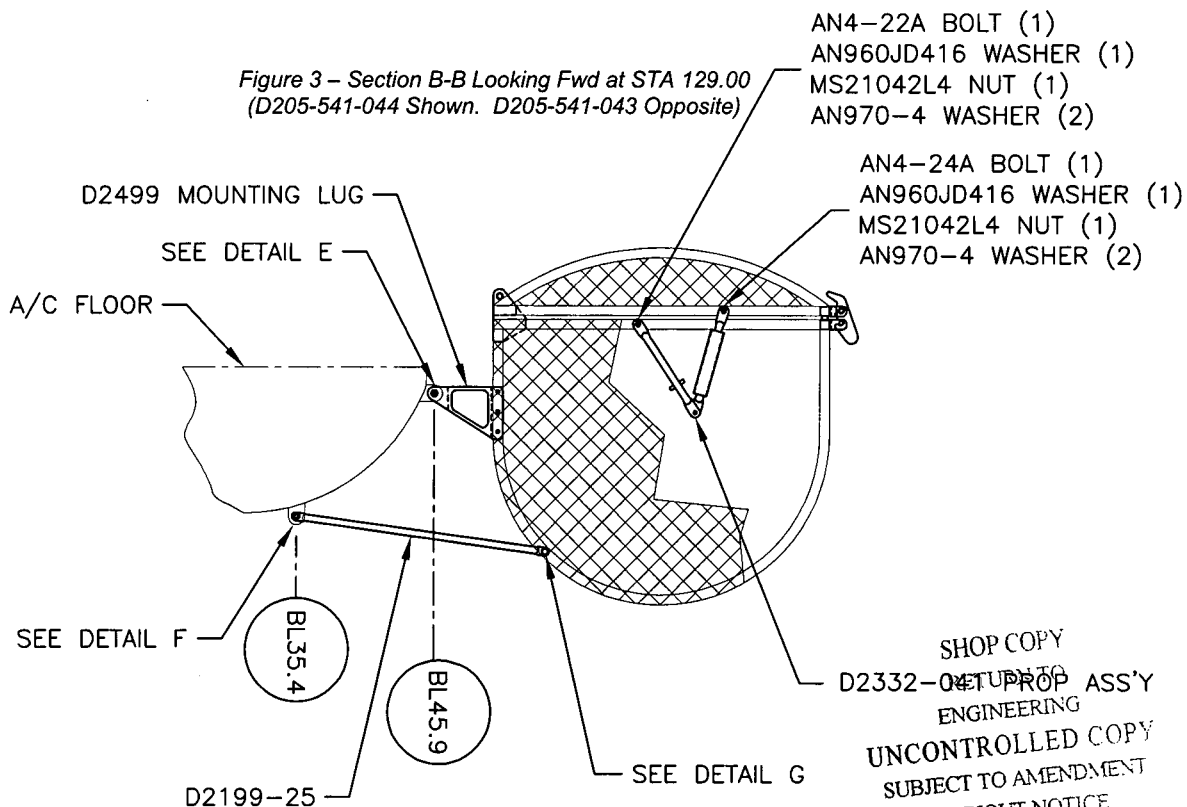


Figure 4 - Section C-C Looking Fwd at STA 155.06
(D205-541-044 Shown. D205-541-043 Opposite)

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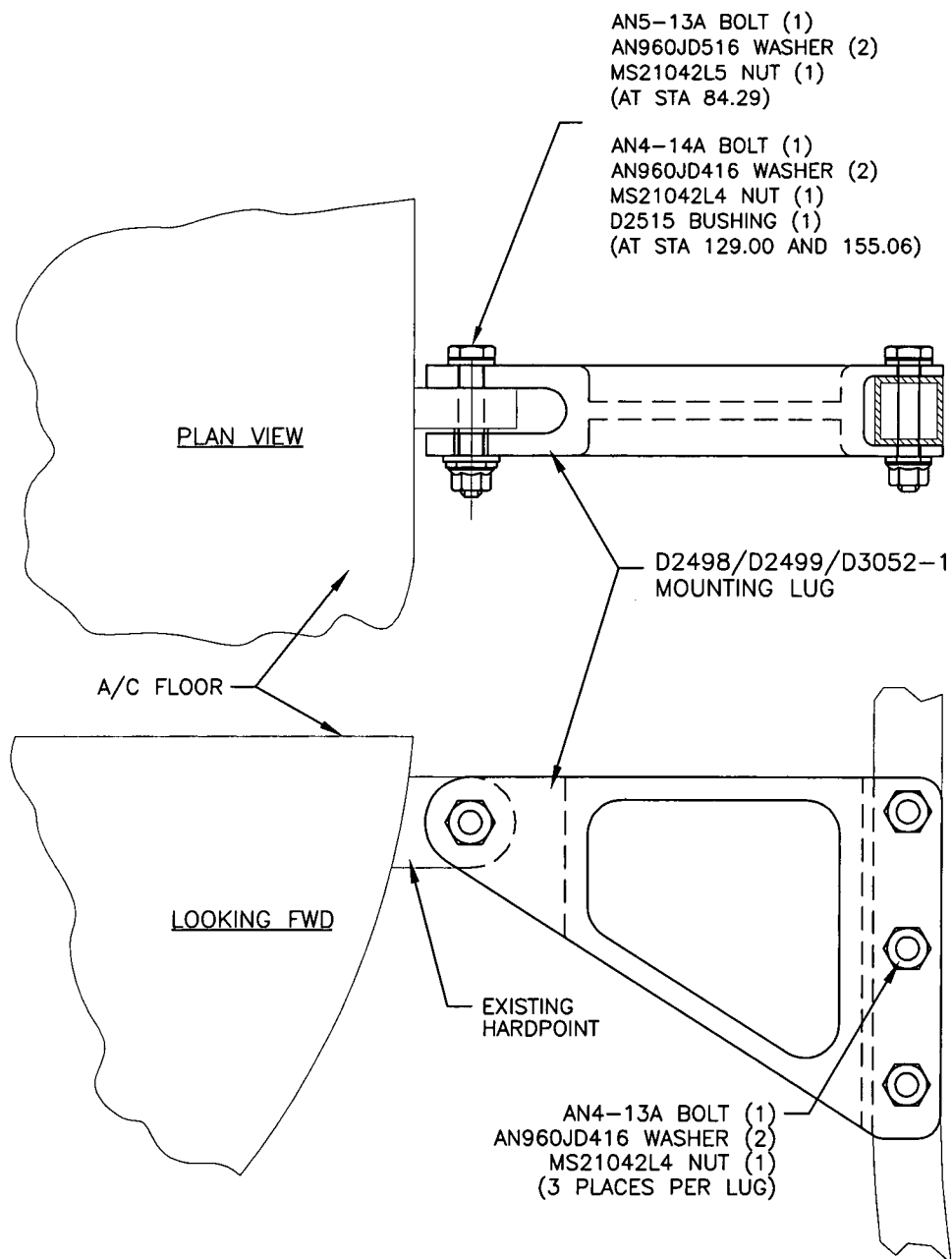


Figure 5 - Detail E Mounting Lug Installation.

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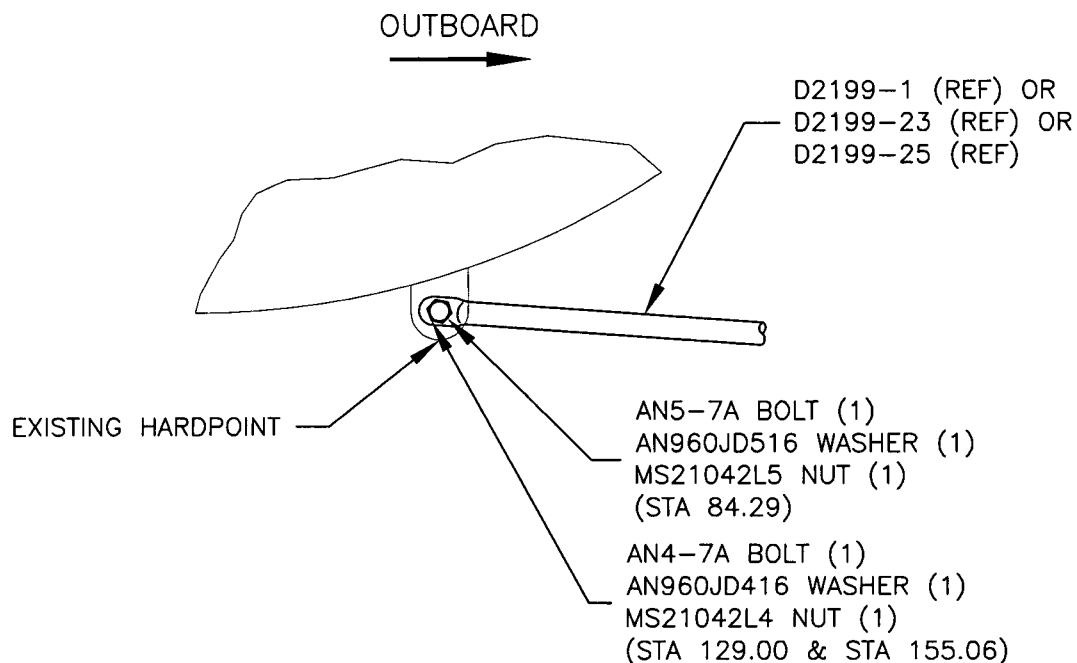


Figure 6 – Detail F Strut to Hardpoint Attachment.

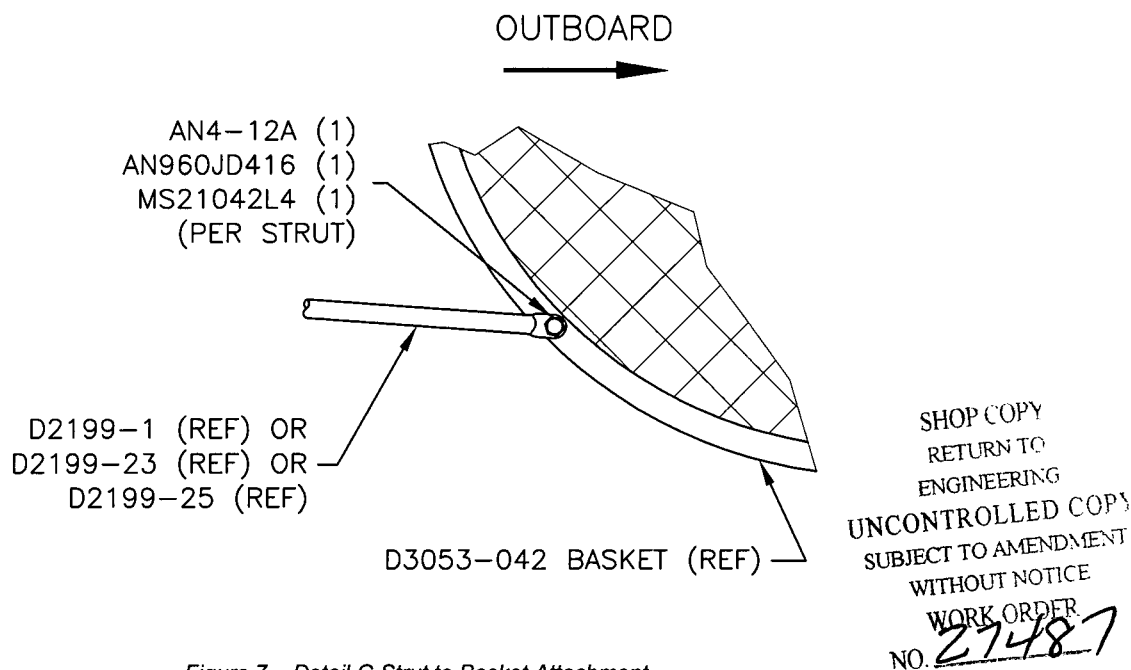


Figure 7 – Detail G Strut to Basket Attachment.

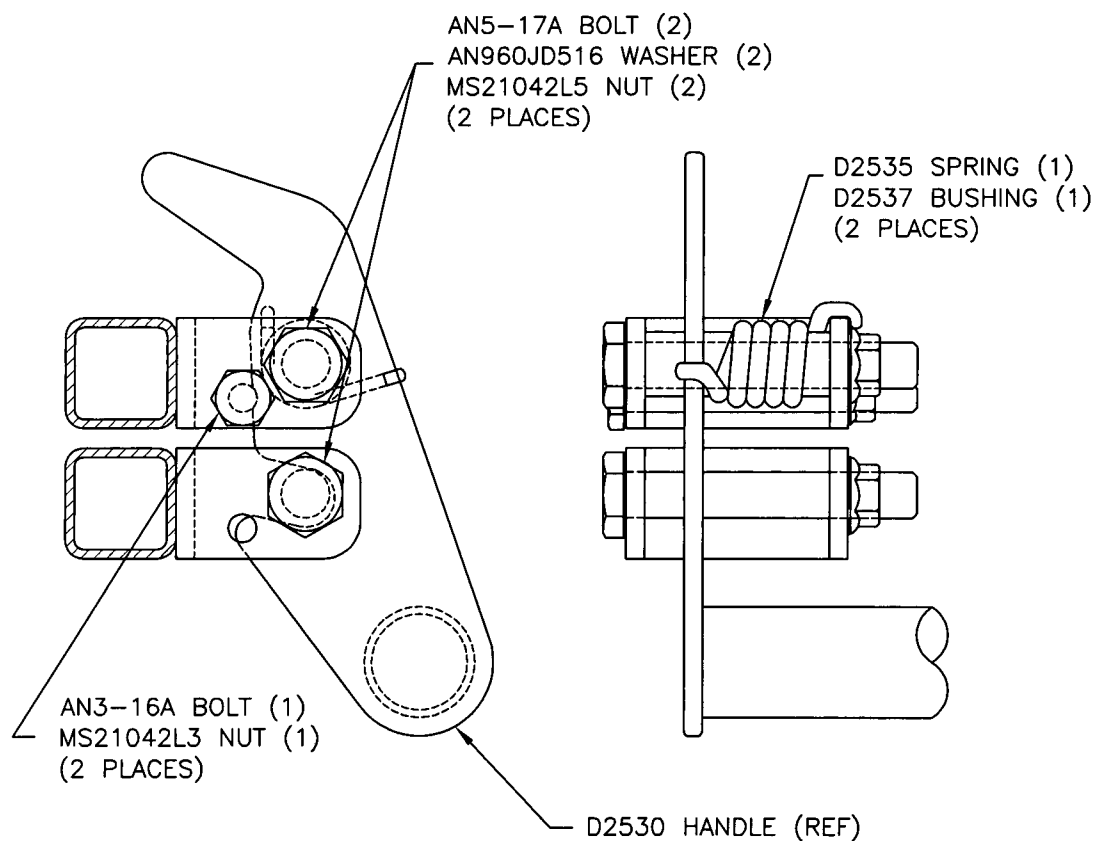


Figure 8 – Detail H Handle Assembly.

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-541-043 Heli-Utility-Basket™	118 lb 53.6 kg	- 63.13 in - 1.60 m	- 7449 in-lb - 85.8 m-k-g	132.25 in 3.36 m	15606 in-lb 180.1 m-k-g
D205-541-044 Heli-Utility-Basket™	118 lb 53.6 kg	+ 63.13 in + 1.60 m	+ 7449 in-lb + 85.8 m-k-g	132.25 in 3.36 m	15606 in-lb 180.1 m-k-g

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